
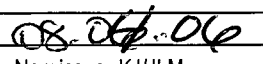









Date: Monday, 07/04/2008 2:30:25 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: TUBE ASSEMBLY 23"								
<b>Job Number</b>	: 38450	<b>Part Number</b>	: D3298005								
<b>Estimate Number</b>	: 11192	<b>Drawing Number</b>	: D3298 REV A2								
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A								
<b>This Issue</b>	: 07/04/2008	<b>Drawing Revision</b>	: A2								
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:								
<b>First Issue</b>	: / /	<b>Due Date</b>	: 30/04/2008								
<b>Previous Run</b>	:	<b>Qty:</b>	6 Um: Each								
<b>Written By</b>	:										
<b>Checked &amp; Approved By</b>	:  										
<b>Comment</b>	: Est A04.09.02 New issue KJ/JLM										
<b>Additional Product</b>											
Job Number: 											
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>									
1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W									
											
<b>Comment:</b> Qty.: 2.0124 f(s)/Unit Total: 8.0497 f(s) Cut tube to length as per Dwg D3298 Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035) Identify as D3298-005 Batch: <u>M103763</u> x6											
2.0	MS208196D	Sleeve									
											
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total: <del>8.0000</del> Each(s) 12 Sleeve Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>MS20819-6D</td> <td>Sleeve</td> <td><u>M107534</u></td> </tr> </tbody> </table>				Qty	Part Number	Description	Batch	2	MS20819-6D	Sleeve	<u>M107534</u>
Qty	Part Number	Description	Batch								
2	MS20819-6D	Sleeve	<u>M107534</u>								
✓ ml											
3.0	AN8186D	Nut									
											
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total: <del>8.0000</del> Each(s) 12 Coupling Nut Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN818-6D</td> <td>Nut</td> <td><del>1013</del> 103154 x 12</td> </tr> </tbody> </table>				Qty	Part Number	Description	Batch	2	AN818-6D	Nut	<del>1013</del> 103154 x 12
Qty	Part Number	Description	Batch								
2	AN818-6D	Nut	<del>1013</del> 103154 x 12								
✓ ml 08/04/09											

Date: Monday, 07/04/2008 2:30:25 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 23"

Job Number: 38450

Part Number: D3298005

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-005T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

x 6

ml 08/04/09

PTO  
last  
page

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 08/04/09 (x 6)

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 195

8/4/09

SD (6x)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion



mf 08-04-09

W



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DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS
A	04.07.06	NEW ISSUE	
A1	04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

**RELEASED**  
04.07.09

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

**Notes:**

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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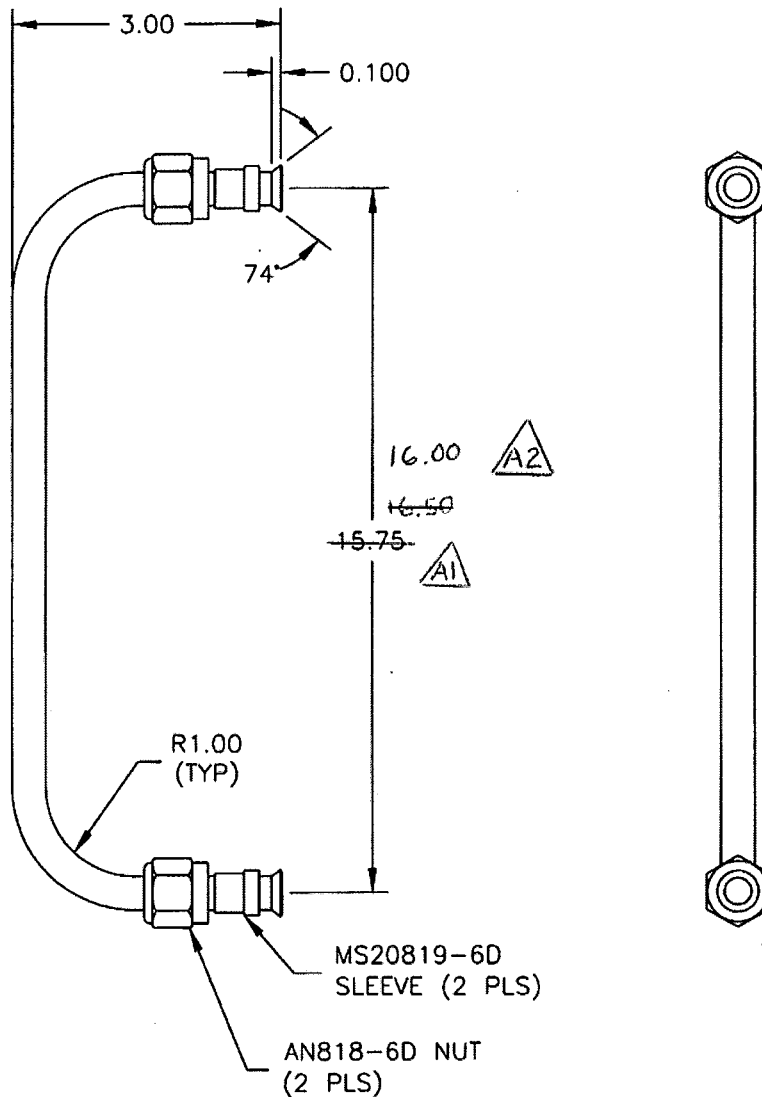
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04.09.04 #



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D3298-001

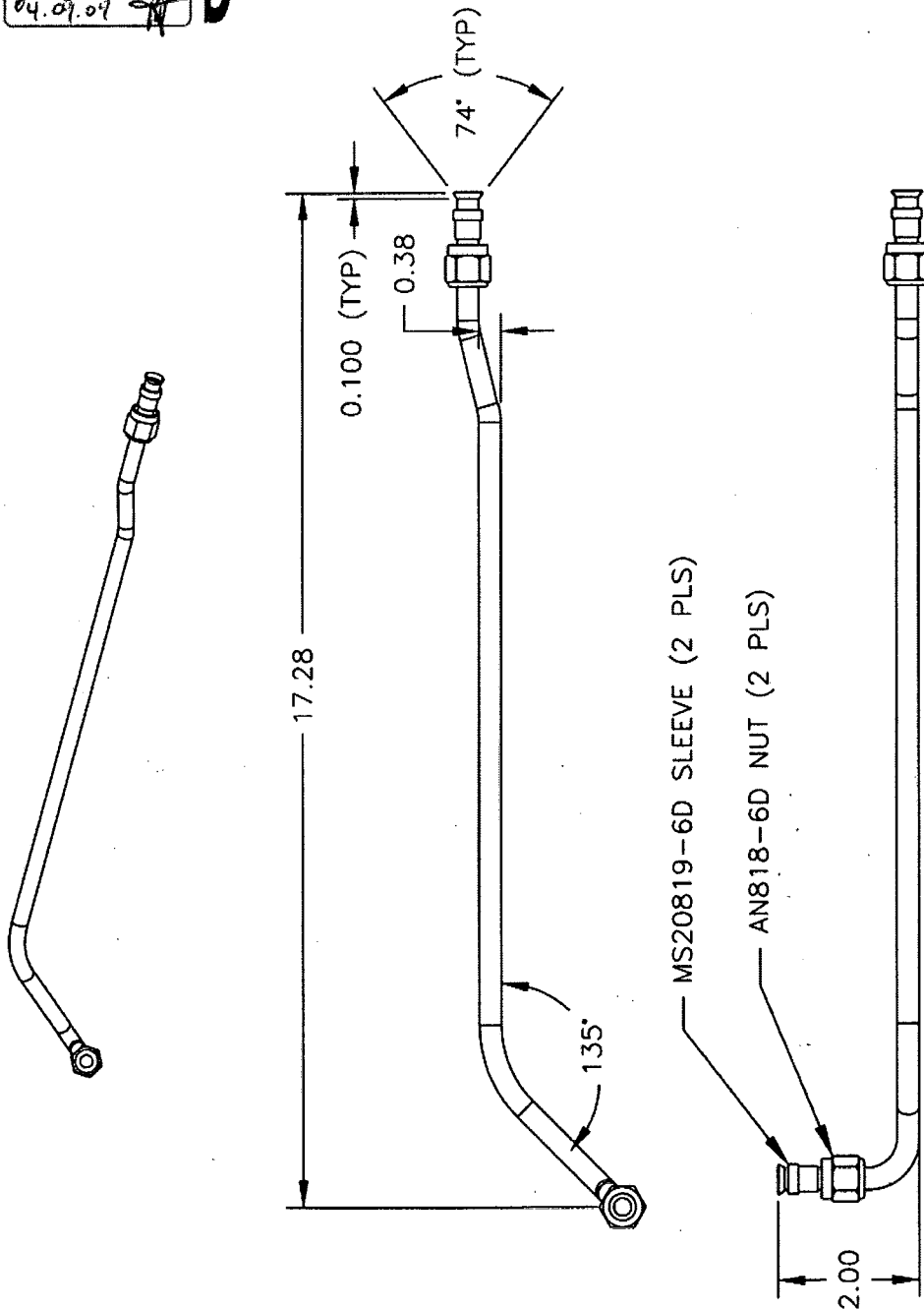
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D3298-005

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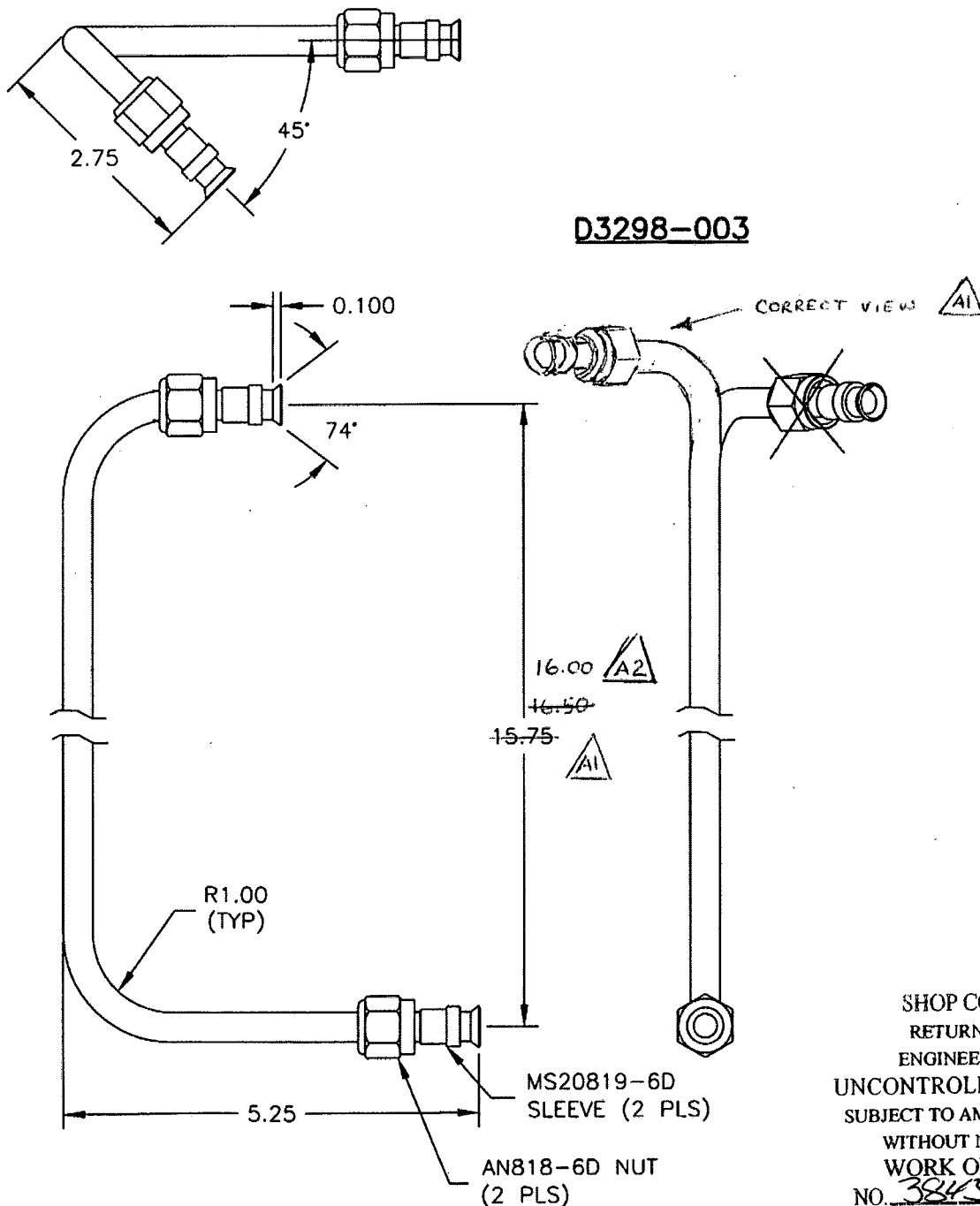
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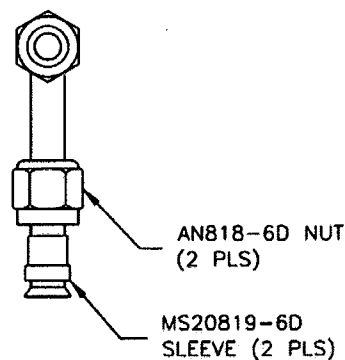
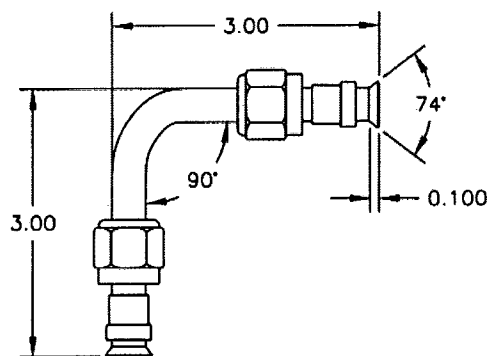
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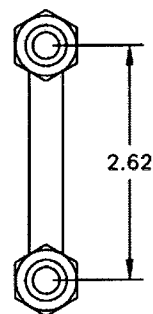
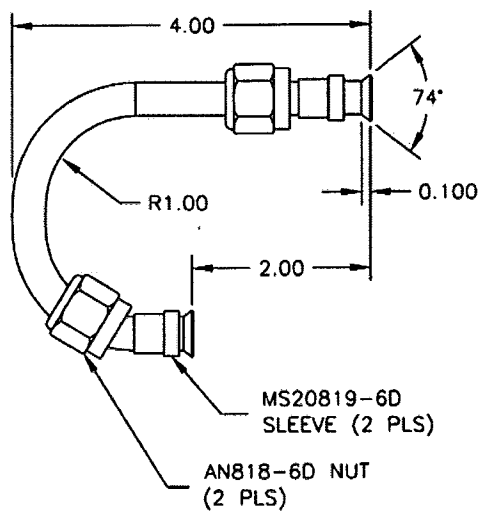


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**D3298-007**



**D3298-013**

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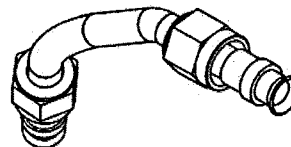
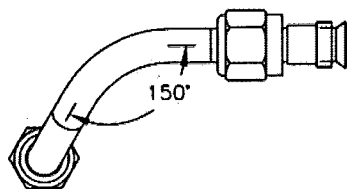
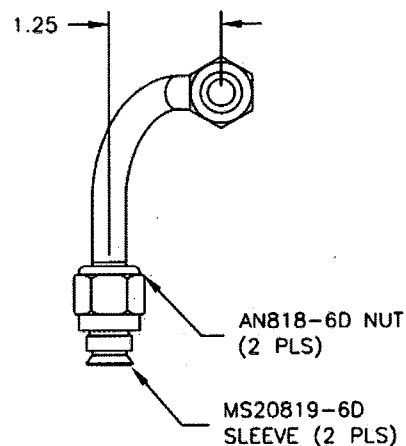
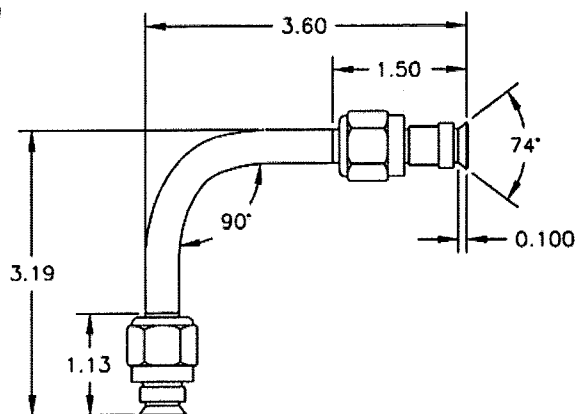
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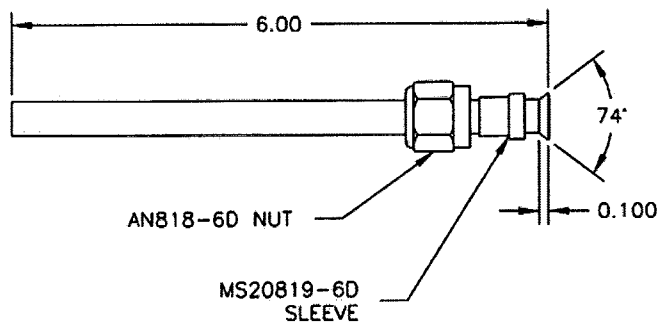


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**D3298-011**



**D3298-009**

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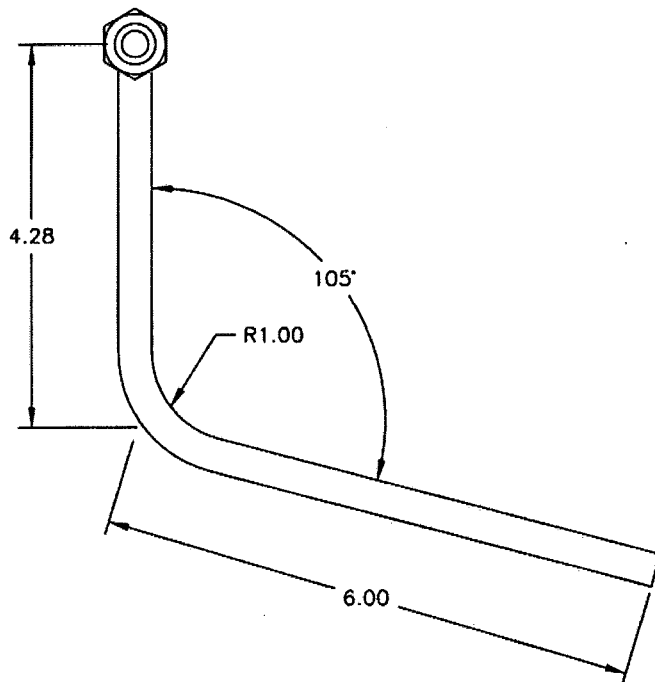
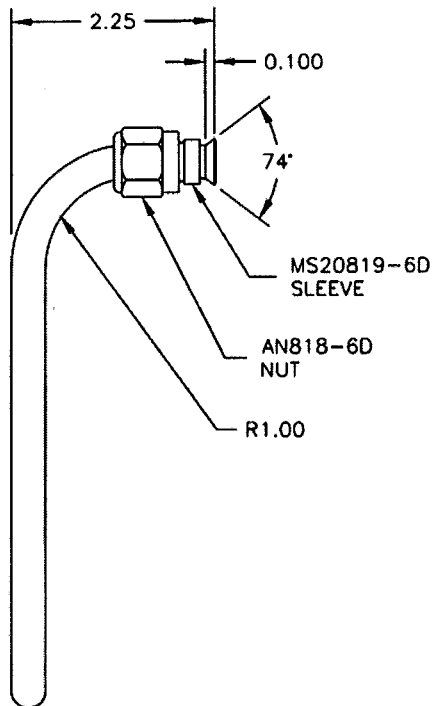
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D3298-015

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3298-005 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>38450</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/08	4	Scrap 2 D3298-005 Bad Bend Hard to be concentrate! music make me crazy!	<i>[Signature]</i> 05/04/08	Scrap and replace X2 <u>M103763</u> Employee to wear Ear protection Per H.S recommendation to reduce noise levels	<i>[Signature]</i> 08/04/09	<i>[Signature]</i> 08/04/09	<i>[Signature]</i> 05/04/08	<i>[Signature]</i> 08-04-09

NOTE: Date & initial all entries